



Dart Aerospace Ltd.
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D3649-041
Job Sheet 183953



Part No: D3649-041

Job Qty: 1 ea

Part Name: Tunnel Bottom Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 07-09-26 EC verified by: DD IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC IPP Rev:C Ecn1162 08-04-02 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	1 pcs		10/12/18	0.00	0.58	Waterjet 1		SC 15/10/18
110	QC	1 pcs		10/12/18	0.00	0.00	QC2 Waterjet-2		SC 15/10/18 DAS
120	QC	1 pcs		10/12/18	0.00	0.00	QC8-3		QC 1 8 2018 68
130	Brake NC	1 pcs		10/12/18	0.00	0.72	Brake NC 2		08 9-89
140	QC	1 pcs		10/12/18	0.00	0.00	QC5		DAS DEC 1 1 2019 40
150	Small Fab	1 pcs		10/12/18	0.00	1.09	Small Fab-4		58 9-89 DEC 1 1 2019 40
160	QC	1 pcs		10/12/18	0.00	0.00	QC5		08 9-89 DEC 1 1 2019 40
170	Packaging	1 pcs		10/12/18	0.00	0.00	Packaging3-1		08 9-89 DEC 1 1 2019 40
180	QC21-SA	1 Ea		10/12/18	0.00	0.00	QC21		SVC

Part Op **100** - 1-Cut as per Dwg D3649 Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D3649

140 - QC5- Inspect part completeness to step on W/O

150 - 1- Form dimple for MS20427M3 rivet per dwg D3649 *****ensure dimples are on the proper side***** 2-

Assemble nutplates as per dwg D3649

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location: ST 232 B

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S26GA	304/316 0.018 Sheet	6.0690 sf (6.069 ea)	100-Waterjet	FM132320
MS20427M3-3	Rivet	88 Ea (88 ea)	140-QC	S120514
MS21060-3K	Nut Plate	22 Ea (22 ea)	140-QC	FM1322567
MS21062-3K	Nut Plate	22 Ea (22 ea)	140-QC	FM132325

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S26GA	6	46	0
140-QC	MS20427M3-3	88	451	0
	MS21060-3K	22	113	0
	MS21062-3K	22	139	0
Part Specifications				
Specifications could not be found.				

Plex 10/1/18 10:04 AM Dart.Gagnon.Michelle

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DART
AEROSPACE

Container No: S118499
Part: D3649-041
Job No: 183953
Serial No/Batch: S118499
Revision:
Inspector:
Exp Date:
Instructions: Various STCs

Date: 10/15/18

DART AEROSPACE LTD		Work Order:	183953
Description: Tunnel Bottom Panel Assy		Part Number:	D3649-041
Inspection Dwg: D3649	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
44,17	+/- 0,030	44,17	1		VSc-01	
18,46	+/- 0,030	18,46	1		Tap2	
44,57	+/- 0,030	44,57	1			
44,50	+/- 0,030	44,50	1			
19,64	+/- 0,030	19,644	1			
16,64	+/- 0,030	16,642	1			
13,80	+/- 0,030	13,808	1			
16,61	+/- 0,030	16,62	1			
13,76	+/- 0,030	13,766	1			
5,98	+/- 0,030	5,989	1			
3,38	+/- 0,030	3,386	1			
2,75	+/- 0,030	2,757	1			
1,49	+/- 0,030	1,489	1			
3,30	+/- 0,030	3,306	1			
2,33	+/- 0,030	2,333	1			
1,15	+/- 0,030	1,156	1			
0,60	+/- 0,030	0,616	1			
0,88	+/- 0,030	0,888	1			
5,02	+/- 0,030	5,025	1			
0,70	+/- 0,030	0,706	1			
0,46	+/- 0,030	0,467	1			
11,76	+/- 0,030	11,76	1			
10,11	+/- 0,030	10,111	1			
Ø0,196	+0,005-0,001	Ø0,196	1			
Ø0,098	+0,004-0,001	Ø0,098	1			
Ø0,250	+0,005-0,001	Ø0,250	1			
0,018	+/- 0,010	0,017	1			

Measured by:	SC	Checked by:	DAS 68	QC Inspector:	
Date:	18/10/15	Date:	9-89	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	